



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7815
Job Sheet 181404



Part No: 647.7815

Job Qty: 50 ea

Part Name: Fwd Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV A RQ 13/12/23 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Machining-1		SBL/VHS 18/09/25
100	Bandsaw	50 pcs	9/10/18	9/10/18	0.00	0.03	Bandsaw1		SBL 18/09/25
110	CNC Vertical Machining	50 pcs	9/10/18	9/10/18	0.13	36.10	HAAS1-1		SBL 18/09/25
120	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Machining-1		
130	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC8 Machining-1		
140	Outsource	50 pcs	9/10/18	9/10/18			ATG001-VC	5	SEP 26 2018
150	Packaging	50 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2		OCT 10 2018
160	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC5		OCT 24 2018
180	Packaging	50 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		OCT 30 2018
190	QC21-SA	50 Ea	9/10/18	9/10/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks at 4.625"

Descriptions: 110 - 1-Machine per folio FB242

140 - Issue P/O to ATG : 20041157 Hard Anodize, Color Black and Prime as Per Dwg. 647.7800 Rev. A

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6B1.500X1.500	7075 T6 Bar 1.500 X 1.500	19.2500 ft (.385 ea)	90-Start up Operation	5113567

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6B1.500X1.500	19	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Bracket	0.800Degrees ± 0.500	1.300 0.300	Angle	
2	Fwd Bracket	151.500Degrees ± 0.500	152.000 151.000	Angle	
3	Fwd Bracket	41.900Degrees ± 0.500	42.400 41.400	Angle	
4	Fwd Bracket	71.700Degrees ± 0.500	72.200	Angle	



Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS		Water Jet _____		Engineering _____	
Part No. _____				Job No: 181404		Coor. _____		Quality _____	
NCR No. _____				Serial No/Batch: S113568		Packaging _____		Other _____	
Date : _____		Description Work _____		Part: 647.7815		Container No: S113568		MRB (QSI042) Approval _____	
Date: 09/25/18				Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Completed By _____			
						Lead hand / Supervisor Approval Verification _____			
								QC / QA Coordinator Approval _____	
Root Cause		FAULT CATEGORY							
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong				
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions				
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance				
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect				
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing				
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved				
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing				
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish				
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread				
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence				
Past Expiry Date	Manufacturing Process								
Misidentified	Past Due	OTHER :							

			71.200	
5	Fwd Bracket	0.436Inches ± 0.002	0.438 0.434	
6	Fwd Bracket	0.030Inches ± 0.005	0.035 0.025	
7	Fwd Bracket	2.705Inches ± 0.002	2.707 2.703	
8	Fwd Bracket	3.955Inches ± 0.002	3.957 3.953	
9	Fwd Bracket	4.440Inches ± 0.005	4.445 4.435	
10	Fwd Bracket	0.448Inches ± 0.002	0.450 0.446	
11	Fwd Bracket	0.177Inches $+ 0.005$ $- 0.001$	0.182 0.176	Diameter
12	Fwd Bracket	0.140Inches ± 0.005	0.145 0.135	
13	Fwd Bracket	45.000Degrees ± 0.500	45.500 44.500	
14	Fwd Bracket	0.170Inches ± 0.005	0.175 0.165	
15	Fwd Bracket	0.170Inches ± 0.005	0.175 0.165	
16	Fwd Bracket	0.125Inches ± 0.005	0.130 0.120	Radius

Plex 7/26/18 8:17 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041157**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041157
PO Date: 9/26/18
Due Date: 10/19/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181406	647.7816	Aft Bracket Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	-	10/19/18	50 pcs	0 pcs	50 pcs	\$10.45/pcs	\$522.50
2	181404	647.7815	Fwd Bracket Issue P/O to ATG : Hard Anodize, Color Black and Prime as Per Dwg. 647.7800 Rev. A	Firmed	-	10/19/18	50 pcs	0 pcs	50 pcs	\$8.35/pcs	\$417.50

Grand Total: \$940.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/3/18 8:59 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916205

Date: 10-Oct-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
50 ea	Part: 647.7815 Fwd Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23833	Rev: A	
	PO: PO041157	Line: 2	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>12/10/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

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Made in Canada.

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